

Work Order ID 54201

December 2, 2009 3:27:26 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 03/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 17/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

02/12/2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

) 11/9/12/19

B54201

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 11/9/12/19

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 80912109



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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M112860

BE 09/12/10

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M112860

BE 09/12/10

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

AWM 9-12-10

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150

QC10- Inspect visual per QSI004- ground welds

0.00



27 Salizli

QC

Memo

0.00



Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



27 Salizli

QC

Memo

0.00



Quality Control

170

Pressure Wash per QSI005 4.3

0.00



BP 09-12-11

HandFinish

Memo

0.00



Hand Finishing

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Stop



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M112148</i> Memo START TIME: <u>9:00</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>9:30</u>	0.00 0.00		<i>BL 09-12-11</i>		<i>①</i>			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>=> M 09/12/11</i>		<i>(X) ①</i>	<i>φ</i>		

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

=> M 09/12/14



Q

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

LA/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345

Sikaflex expire date: 10/09

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345

Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M112763

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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210 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 04

0.00

27802/12/14



220 Packaging 0.00



Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

0.00

12/12/09

12/12/22 (1)

230 QC21- Final Inspection - Work Order Release 0.00



QC

Quality Control

Memo

0.00

12-24

C209112123

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Picklist Print

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Work Order ID: 54201



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2580-1RevD

Manufactured

No

110

Each

4.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53539

53540

4

2

2

140

Each

159.0000

1.0000

D2576-3RevG

Manufactured

No



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43504

46661

52215

159

11

101

47

[Handwritten signature]

B6 09/12/10

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2579RevE

Manufactured

No

140

Each

135.0000

20.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

13

51525

13

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

D2855RevA

Manufactured

No

200

Each

58.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

58

50513

1

50770

3

51539

54

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Comments:

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Required Qty: 1.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-5A 		Purchased	No			200	Each	2,043.000	2.0000			
Bolt												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2043	
	100188	188	
	105057	1855	

x2 09/12/14

AN960JD10L 		Purchased	No			200	Each	5,443.000	2.0000			
Washer												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	5443	
	101291	16	
	104885	153	
	105793	236	
	109632	280	
	110985	4758	

x2 09/12/14

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ALS7-1032-130		Purchased	No			200	Each	2,748.000	50.0000			

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2748	
105855	16	
108606	52	
11529	1356	
111779	313	
112772	11	
113238	1000	

X 50 04/12/11

AN3C4A

Purchased

No

200

Each

1,247.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1247	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	216	
113226	1000	

1113359

X 50 04/12/11

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L		Purchased	No			200	Each	1,682.000	50.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



washer

Warehouse	Location	Loc Qty	Loc Code
OFFSHORE			
FG		100	
103585		100	
Main Warehouse			
ST		1582	
12116		512	
112612		342	
112933		728	

D3566-13RevC

Manufactured No



Gasket

200	Each	106.0000	1.0000
-----	------	----------	--------

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse			
FP		104	
51606		21	
53461		83	
Main Warehouse			
ST		2	
45717		1	
50265		1	

X50 Hl 09/12/14

X1 Hl 09/12/14

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D3566-5RevC		Manufactured	No			200	Each	31.0000	1.0000			

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

26

53804

26

Main Warehouse

FP19

1

52909

1

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

XLH1091214

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D3566-1RevC

Manufactured

No

200

Each

31.0000

2.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

26

52512

3

53790

23

Main Warehouse

ST

5

46349

1

51218

1

51259

3

D3564-11RevD

Manufactured

No

200

Each

28.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

26

52125

14

53808

12

Main Warehouse

ST

2

45823

1

50112

1

X241 09/12/14

X1 41 09/12/14

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 3:27:33 PM

Work Order ID: 54201

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 03/12/2009

Required Date: 17/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-13RevD

Manufactured

No

200

Each

46.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP17

34

51611

32

52059

2

Main Warehouse

ST

12

45409

2

46495

10

x1 21/09/12/14

D3564-9RevD

Manufactured

No

200

Each

4.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

2

52593

2

Main Warehouse

ST

2

44659

1

45825

1

B53806

x1 21/09/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 3:27:33 PM

Work Order ID: 54201

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-5RevD

Manufactured

No

200

Each

29.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

23

51925

1

53805

22

Main Warehouse

ST

4

45824

1

47433

1

52595

2

X 1 09/12/11

D2594-3RevC

Manufactured

No

200

Each

602.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

575

52562

575

X 16 09/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 3:27:33 PM

Page 10/10

Work Order ID: 54201



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	314.0000	16.0000			

Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	121	
64008	121	
Main Warehouse		
ST	193	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	71	

X16 41 09/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN
ENCLOSURE
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54201
B/09-12-2

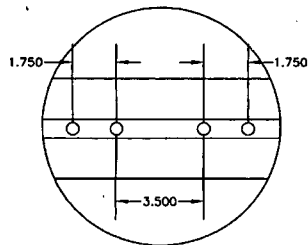
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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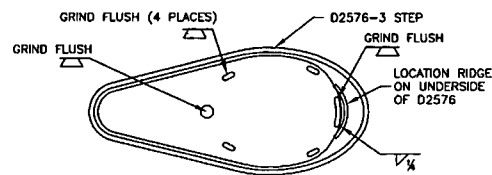
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DETAIL A
SCALE 5:24

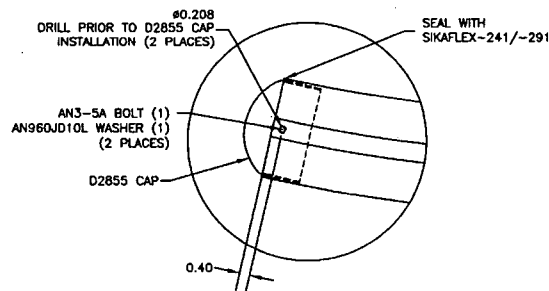


RELEASED
07-08-28

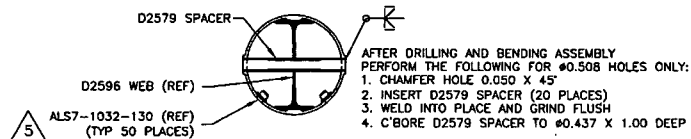
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



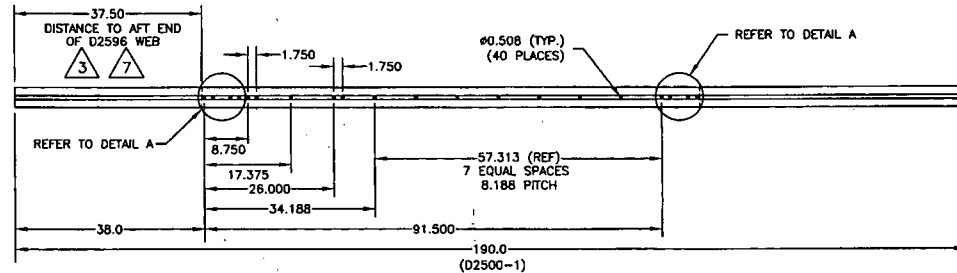
SECTION D-D
SCALE 5:24



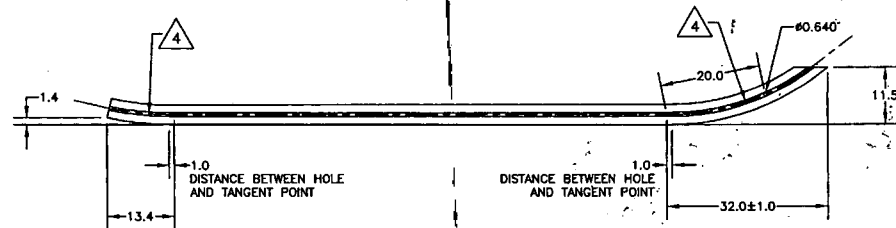
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

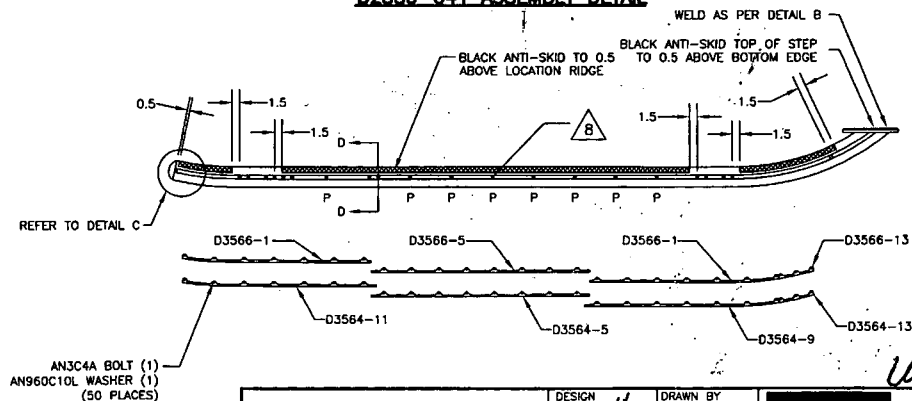
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN #	DRAWN BY AH	DART DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA	REV. D
CHECKED #	APPROVED #	DRAWING NO. D2580	SHEET 2 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a circular component with the following labels and dimensions:

- #0.208
- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-SA BOLT (1)
- AN960J10L WASHER (1)
- (2 PLACES)
- SEE NOTE ii)
- D2855 CAP
- 0.40

Diagram illustrating the assembly of the D2579 spacer. The assembly consists of a central web (D2596) and a spacer (D2579) which is inserted into the web. The web is bent to form a U-shape, and the spacer is inserted into the web. The assembly is then welded into place and ground flush. The dimensions and assembly instructions are provided below the diagram.

Labels in the diagram:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

Assembly Instructions:

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2598 WEB
3 7
1.750 1.750
REFER TO DETAIL A
8.750
17.375
26.000
34.188
38.0
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
91.500
190.0
(D2500-1)
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL E

(MAKE FROM D2580-1 DRILLING DETAIL)

5.985

5.338 (REF)

51.340

39.580

5.915

3.630 (REF)

#0.508 (8 PLACES)

20.0

1.4

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

13.4

32.0 ± 1.0

11.0

12' x 12' x 12' CONCRETE PILE CAP

D3560-V49 ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

H

NO C'BORE NO PLUG

NO C'BORE NO PLUG

8

P

H

P

P

P

P

P

P

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13


AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

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	CHECKED	APPROVED		DRAWING NO.	REV. C
	DATE	TITLE			SHEET 3 OF 3
	07.02.27	205 SKIDTUBE ASSEMBLY			SCALE 1:24

NO. 219

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 53918
Part number: D205-634-041
Description: 205 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet. Durb Date of Test Coupon 09.12.04
Welder Barclay Elliott Date of Test Coupon 09.12.04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

REFERENCE ONLY